Work Order ID 116565

April-17-14 12:51:28 PM

116565

Item ID: D4885-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: End Fitting

Start Date: 4/17/14 **Start Qty:** 1.00 *1*

Required Date: 5/02/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 14-04-17 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4885	**Revision Nbr** Rev A 14/04/21								
100		0.00							
100									
Outsource5	**Memo**	0.00							
Outsource process - Machining	ISSUE P/O: 23860 POSSIBLE SUPPLIER:ATG C OF C IS REQUIRED								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	**Memo**	0.00							
Quality Control									
150		0.00							
150	PURCHASING								
Purchasing	**Memo**	0.00							
Purchasing	Issue P/O: _____ LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required								

14/6/25

CL 14/04/22 (1)

14/4/22 (1)

1

CL 14/06/25

N/A ddned ATG

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Item ID: D4885-5 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: End Fitting
Start Date: 4/17/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 5/02/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00				1X			8P 14-6-25
160									
Packaging	**Memo**	0.00							
Packaging	Ensure certificate of conformity is attached								
190	QC21- Final Inspection - Work Order Release	0.00				1X			8P 14-6-25
190									
QC	**Memo**	0.00							
Quality Control									

ST 126

MCJ 14-6-25

14-6-25

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- ☐ Rework
- ☐ Scrap
- ☐ Use-as-is
- ☐ Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

- ☐ Skid-tube
- ☐ Machining
- ☐ Thermoforming
- ☐ Large Fab
- ☐ Crosstube
- ☐ Small Fab
- ☐ Finishing
- ☐ Composite
- ☐ Water Jet
- ☐ Prod. Eng. Coor.
- ☐ Rec/Store/Packaging
- ☐ Supplier
- ☐ Engineering
- ☐ Quality
- ☐ Other
- ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
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- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

April-17-14 12:51:31 PM

Work Order ID: 116565 *116565*

Parent Item: D4885-5 *D4885-5*

Parent Item Name: End Fitting

Start Date: 4/17/14 **Required Date:** 5/02/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A NEW ISSUE 14-01-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4885-5P		Purchased	No				Each	0.0000		1			
D4885-5P End Fitting									**	1X SP/4-6-26			
M174PH-H900R2.000		Purchased	No				f	51.0458		1			
M174PH-H900R2.000 17-4SS H900 ROUND BAR 2.000									**	CL 4/04/22			

Location	Loc Qty	Loc Code	
MAT031	51.0458		
M128314	26.4		1
M128809	24.6458		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

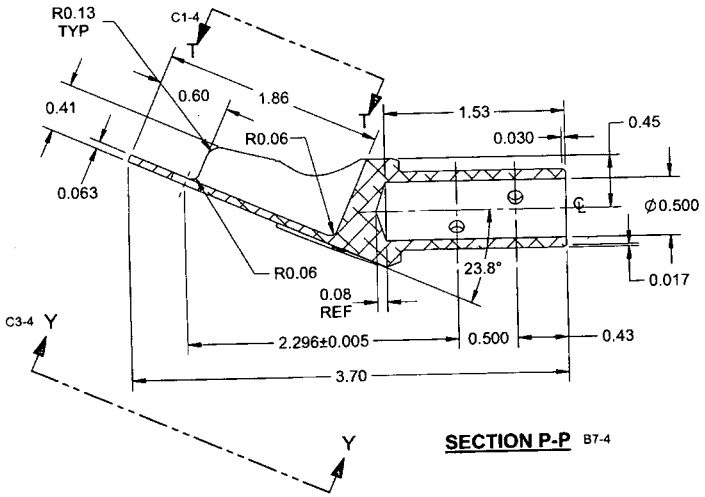
☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
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☐ Out of Sequence

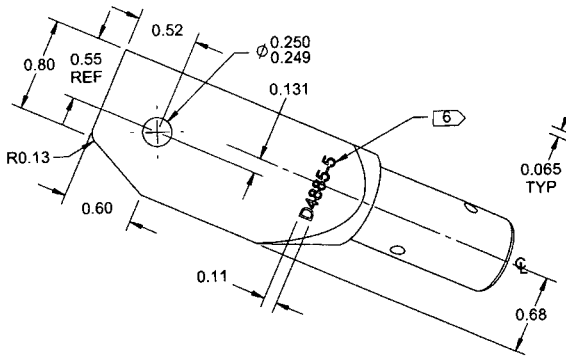
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

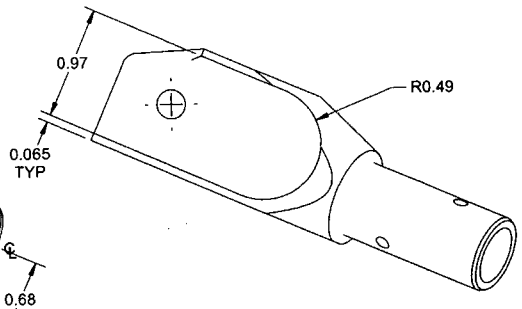
☐ Other



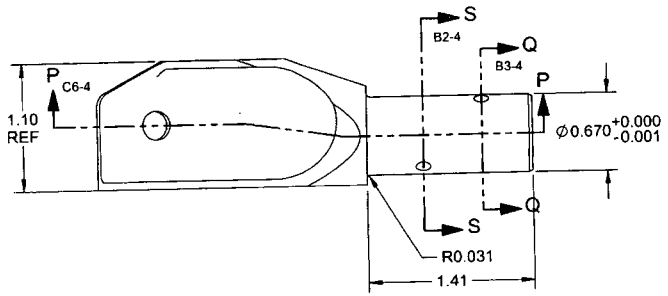
SECTION P-P B7-4

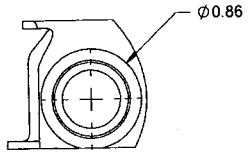


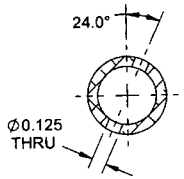
AUXILIARY VIEW Y-Y C8-4



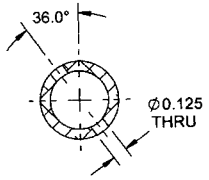
AUXILIARY VIEW T-T D7-4







SECTION Q-Q B6-4



SECTION S-S B6-4

D4885-5 END FITTING

2013-12-12

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.11 HIGH LETTERS TO A MAX. DEPTH OF 0.010
7) WEIGHT: 0.21 lbs
8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	DC	DRAWING NO. D4885 REV. A
MFG. APPR.	JLM	SHEET 4 OF 5
APPROVED	HS	TITLE END FITTING SCALE NTS
DE APPR.	DS	
DATE	13.12.01	

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116565MLJ
1404-17

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23860

Purchase Order Date 4/17/2014
PO Print Date 4/22/2014

Order From : VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA – (Free Carrier)

16	D4885-2P	End Fitting	5/14/2014 Yes 5/14/2014	FN	1.00 Each		$96.00	$96.00

MACHINE AS PER DWG D4885 REV. A
B116572
MATERIAL: 174PH-H900R2.000 M128314

Line Total: **$96.00**

17	D4885-5P	End Fitting	5/14/2014 Yes 5/14/2014	FN	1.00 Each		$96.00	$96.00

MACHINE AS PER DWG D4885 REV. A
B116565
MATERIAL: 174PH-H900R2.000 M128314

Line Total: **$96.00**

18	D4885-7P	End Fitting	5/14/2014 Yes 5/14/2014	FN	2.00 Each		$96.00	$192.00

MACHINE AS PER DWG D4885 REV. A
B116567
MATERIAL: 174PH-H900R2.000 M128314

Note:

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 908154 Date: 20-Jun-14

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

CHANTAL LAVOIE
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via

Quantity	Description
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.
4 ea	Part: D4870-1P Rev: A END FITTING, SMALL Job: 16223 PO: PO23860 Line: 12
4 ea	Part: D4870-3P Rev: A END FITTING, LARGE Job: 16224 PO: PO23860 Line: 13
1 ea	Part: D4885-5P Rev: A END FITTING Job: 16227 PO: PO23860 Line: 17
8 ea	Part: D4808-1P Rev: A ROD END Job: 16213 PO: PO23860 Line: 2
4 ea	Part: D4805-5P Rev: A END FITTING Job: 16217 PO: PO23860 Line: 6
8 ea	Part: D4805-3P Rev: A END FITTING Job: 16218 PO: PO23860 Line: 7
	DATE : 20 Jun 2014 CERTIFIED SIGNATURE: J Arsenault RECEIVER SIGNATURE : _____ CERTIFICATE OF CONFORMANCE A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT ARE IN CONFORMANCE WITH THE REQUIREMENTS, SPECIFICATIONS, AND DRAWINGS REFERENCED IN THE ABOVE PURCHASE ORDER.

First Article Inspection Report

ATG INDUSTRIES INC.
731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	Dart Aerospace	Date:	June 20th, 2014	503
Part Number:	D4805-5P	Revision:	A	
PO Number:	PO23860	Qty:	4	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
1	1.543±.005	1.540	Section I-I
2	R.06	✓	
3	.30	.304	
4	.500	.502	
5	.38	.380	
6	.030	.030	
7	.017	.017	
8	.315	.318	
9	R.031	✓	
10	Ø.047	.050	2 Places
11	2.89	2.887	
12	Ø.900	.901	
13	.63	.628	
14	.050	.049	
15	20º	20º	
16	.090	.092	
17	.156	.158	
18	.450	.448	
19	Ø.250/.249	.2495	Auxiliary View L-L
20	Note 6	✓	
21	.11	.115	
22	Ø1.00	1.001	
23	Ø.60	.599	
24	Ø.420+.000/-.001	.4198	
25	1.36	1.359	
26	R.03	✓	
27	Ø.60 REF	.599	
28	Ø.75	.750	
29	28.4º	28.6º	Section J-J
30	Ø.125	.125	

First Article Inspection Report

ATG INDUSTRIES INC.
731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	**Dart Aerospace**	Date:	**June 20th, 2014**	**503**
Part Number:	**D4805-5P**	Revision:	**A**	
PO Number:	**PO23860**	Qty:	**4**	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
31	31.6º	31.8º	Section K-K
32	Ø.125	.125	
33	Material:	17-4SS H900 1.375" RD BAR	Supplied by Customer
34	Treatment:	Liquid Penetrant	PO#20140224

skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO21208	**Customer:** ATG Industries Inc	**Dept:** NDT YUL	**Reference:** 20140224
Descr:	**PN:**	**S/N:**	**Qty:** 1
Make:	**Model:**	**Reg:**	**A/C S/N:**
TSN: 0	**CSN:** 0	**TSO:** 0	

Task: UNSCHEDULED | **Sequence:** 1

Work Required:

CARRY OUT NDT ON 55 PARTS AS PER PO : 20140224

Action Taken:	Date:	Initial/Stamp:
LPI C/O AS PER ASTM E-1417M-13 NO CRACK FOUND PEN.(ZL-37 , B#10A070), CLEAN(SKC-S,B#09F21K),DEV.(SKD-S2,B#09L04K) EMU.(ZR-10B,B#10A074).	JUN 17 2014	DOT APP 20 53-89

DAS 27 19-89 14/06/28

Description	*Location*	*P/N*	*Qty*	*Batch*	*S/N Off*	*S/N On*

COPY

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	**ACA/SCA Stamp**	Date:
Name: RAFIK MELIKIAN	DOT APP 20 53-89	JUN 17 2014